



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

~~MAIL~~ ~~BLACK~~

D206-642-351
Job Sheet 189428



Part No: D206-642-351

Job Qty: 1 ea

Part Name: Replacement Skidtube, Low & High Gear, Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/24/19

Job Tracking No:

Due Date: 3/1/19

Created By: Jesse White

Type: SOLD

Description:

Note: DWG D4361-041 REV A, IIN-D206-642 REV Q SHEETS 29-30 IPP REV:A NEW ISSUE 12-07-09 JLM
VERIFIED BY:EC

Ship Via:

Bill of Materials



Container No: S148011



Part: D206-642-351

Job No: 189428

Serial No/Batch: S148011

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/25/19

Black
sanded

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
TOW-RING HOLE is $\phi 0.625$ per dws. TOW RING is $\phi 0.625 \pm 0.010$".			DRILL TOW-RING HOLE AT $\phi 0.640$.		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			

Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	3/1/19	3/1/19	0.00	0.00	Start Up Skid tubes-1	
110	Skid tubes	1 pcs	3/1/19	3/1/19	0.00	3.26	Skid tubes-2	
115	QC	1 pcs	3/1/19	3/1/19	0.00	0.00	QC5	
120	HandFinish	1 pcs	3/1/19	3/1/19	0.00	0.83	HandFinish1	
125	QC	1 pcs	3/1/19	3/1/19	0.00	0.00	QC7-1	
130	Skid tubes	1 pcs	3/1/19	3/1/19	0.00	3.26	Skid tubes-2	
140	QC	1 pcs	3/1/19	3/1/19	0.00	0.00	QC5	
150	Skid tubes	1 pcs	3/1/19	3/1/19	0.00	3.26	Skid tubes-2	
170	QC	1 pcs	3/1/19	3/1/19	0.00	0.00	QC10	
180	QC	1 pcs	3/1/19	3/1/19	0.00	0.00	QC5	
190	HandFinish	1 pcs	3/1/19	3/1/19	0.00	0.83	HandFinish2	
200	Powdercoat	1 pcs	3/1/19	3/1/19	0.00	0.23	Powdercoat1	
210	QC	1 pcs	3/1/19	3/1/19	0.00	0.00	QC3	
220	HandFinish	1 pcs	3/1/19	3/1/19	0.00	0.83	HandFinish4	
230	QC	1 pcs	3/1/19	3/1/19	0.00	0.00	QC3	
240	QC	1 pcs	3/1/19	3/1/19	0.00	0.00	QC5	
245	DC	1 pcs	3/1/19	3/1/19	0.00	0.00	DC	
250	Packaging	1 pcs	3/1/19	3/1/19	0.00	0.00	Packaging3-1	
260	QC21-FG	1 Ea	3/1/19	3/1/19	0.00	0.00	QC21	

Part Op 110 - 1-Deburr Fwd edge of tube 2-Remove ridge on inside of Fwd edge of tube as per Dwg D4361 3-Weld Fwd Cap as per Dwg D4361 4-Grind D2647 to fit as required. 5-Cut aft end to length as per Dwg D4361 6-Drill pilot holes using drill Jig DT8168A and DT8168B and DT8025. Most Fwd wearplate hole to be laid out manually. 8-Open Aft Cap Hole using # Drill Bit 9-Open holes for Tow Ring to Ø0.625" as per Dwg D4361, D4361-041 Drilling Detail 10-Remove inner indexing ridge on aft end of skid tube as per Dwg D4361 11-Deburr and Blow out all chips from inside the tube 130 - 1-Open holes to finished size as per Dwg D4361, D4361-041 Drilling Detail 2-Countersink crossbolt spacer holes as per Dwg D4361 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. 4-Bond D2654-5 web in place as per QSI 015, Ensure holes line up. Allow 12 Hrs. cure time 150 - 1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D4361. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. 2-Grind welds flush as per Dwg D4361. 3-Counterbore 5/16" x 0.750" deep as per Dwg D4361. Deburr 4- Install nut plate as per Dwg 190 - AND ALODINE ONLY AS PER QSI005 200 - Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. 220 - 1-Install wearplates as per Dwg D4361. 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D4361. Clean excess adhesive 6-Wing Walk as per Dwg D4361-041 and QSI 005 4.4 245 - Photocopy bluefile and create labels per PPP D206-642-351 CHG001 250 - Identify and pack for shipping as per PPP D206-642-351

Silkflex: 5128386

exp: 03/07/19

M138940 START: 11:30 TEMP: 320° FINISH: 12:00

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job BOM

008551

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 pcs (1 ea)	90-Start up Operation	5108902
D2647	Cap	1 pcs (1 ea)	90-Start up Operation	5038805
D2654-5	Web	1 pcs (1 ea)	130-Skidtubes	515302
D2649	Cross Bolt Spacer	23 pcs (23 ea)	150-Skidtubes	5050570 x 10 5156881 x 17
AN3-36A	Bolt	9 Ea (9 ea)	220-HandFinish	5152650
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	220-HandFinish	FM1137672
CR3212-4-3	Cherry Rivet	2 Ea (2 ea)	220-HandFinish	FM1137886-0
D2646	Aft Cap	1 pcs (1 ea)	220-HandFinish	5148372
D2651-1	Plug	4 pcs (4 ea)	220-HandFinish	5151045
D2651-3	O-Ring	4 pcs (4 ea)	220-HandFinish	5027458
D2680-041	Nut Plate	1 pcs (1 ea)	220-HandFinish	5148379
D3873-1	Bushing	18 pcs (18 ea)	220-HandFinish	5154066
D4364-041	Run-on Landing Wearplate Fwd	1 pcs (1 ea)	220-HandFinish	5161067
D4364-043	Run-on Landing Wearplate Aft	1 pcs (1 ea)	220-HandFinish	FM1137997
MS21042-3	Nut use MS21042L3 per QSI 017	9 Ea (9 ea)	220-HandFinish	5094502
MS27039-1-08	Screw	2 Ea (2 ea)	220-HandFinish	5104017
MS27039-4-06	Screw	1 Ea (1 ea)	220-HandFinish	FM1137951-0
NAS1149C0332R	Washer	9 Ea (9 ea)	220-HandFinish	5150318
NAS1149D0332J	Washer	2 Ea (2 ea)	220-HandFinish	5123446
NAS1149D0463J	Washer	1 Ea (1 ea)	220-HandFinish	513210

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2620	1	3	0
	D2647	1	16	0
130-Skidtubes	D2654-5	1	13	0
150-Skidtubes	D2649	23	81	0
220-HandFinish	AN3-36A	9	45	0
	CCR264SS3-3	2	283	0
	CR3212-4-3	2	114	0
	D2646	1	25	0
	D2651-1	4	149	0
	D2651-3	4	434	0
	D2680-041	1	35	0
	D3873-1	18	50	0
	D4364-041	1	1	0
	D4364-043	1	4	0
	MS21042-3	9	221	0
	MS27039-1-08	2	507	0
	MS27039-4-06	1	19	0
	NAS1149C0332R	9	3,307	0
	NAS1149D0332J	2	2,744	0
	NAS1149D0463J	1	2,713	0

Part Specifications

Specifications could not be found.

Plex 1/24/19 9:26 AM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D4361-041	SKIDTUBE ASSY
	X	D4361-043	SKIDTUBE ASSY
1	1	D2600-1-160	EXTRUSION
1		D2654-5	WEB
	1	D2654-7	WEB
1	1	D2646	AFT CAP
1	1	D2647	CAP
23	26	D2649	CROSS BOLT SPACER
4	8	D2651-1	PLUG
4	8	D2651-3	O-RING
1	1	D2680-041	NUT PLATE
18	20	D3873-1	BUSHING
1		D4364-041	FWD WEARPLATE ASSY
1		D4364-043	AFT WEARPLATE ASSY
	1	D4366-041	FWD WEARPLATE ASSY
	1	D4366-043	AFT WEARPLATE ASSY
9	10	AN3-36A	BOLT
9	10	NAS1149C0332R	WASHER (OR AN960C10L)
9	10	MS21042-3	NUT
2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	MS27039-1-08	SCREW
1	1	MS27039-4-06	SCREW
1	1	NAS1149D0463J	WASHER (OR AN960JD416)

NOTES:

- MATERIAL: N/A
- FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2654-5/-7 WEB
-POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: D4361-041 = 37.5 LBS
D4361-043 = 44.3 LBS
- WELD PER DART QSI 004
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

RELEASED
R 2011-09-12

A	NEW ISSUE	SC	11.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	BE	D4361	SHEET 1 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	HA	206L/407 SKIDTUBE ASSEMBLIES	NTS
DATE	11.05.05	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Entered: _____ Date: _____

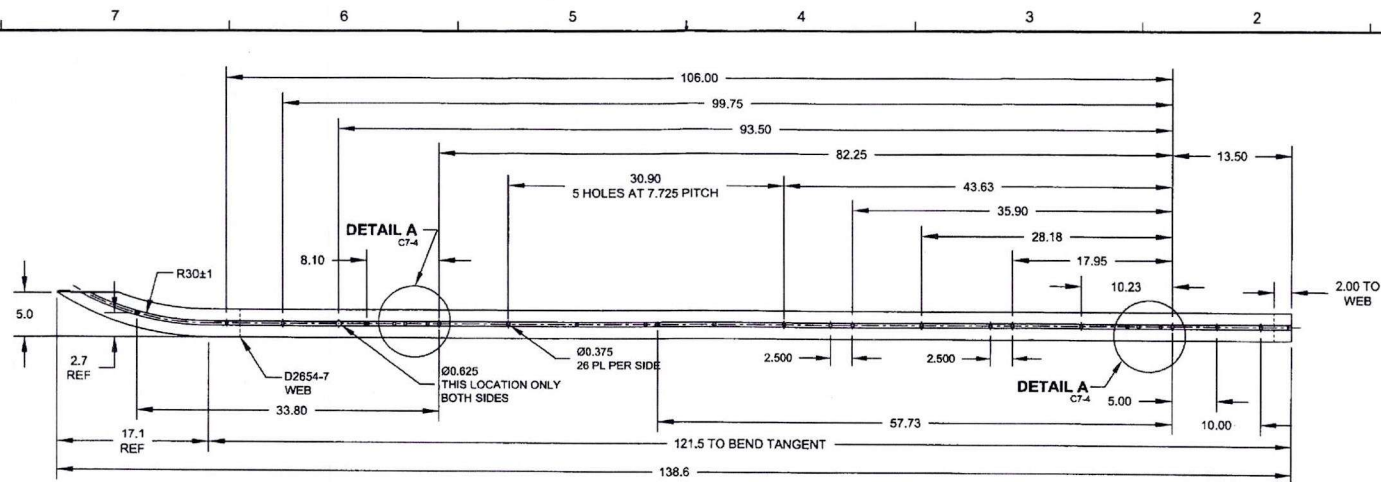


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

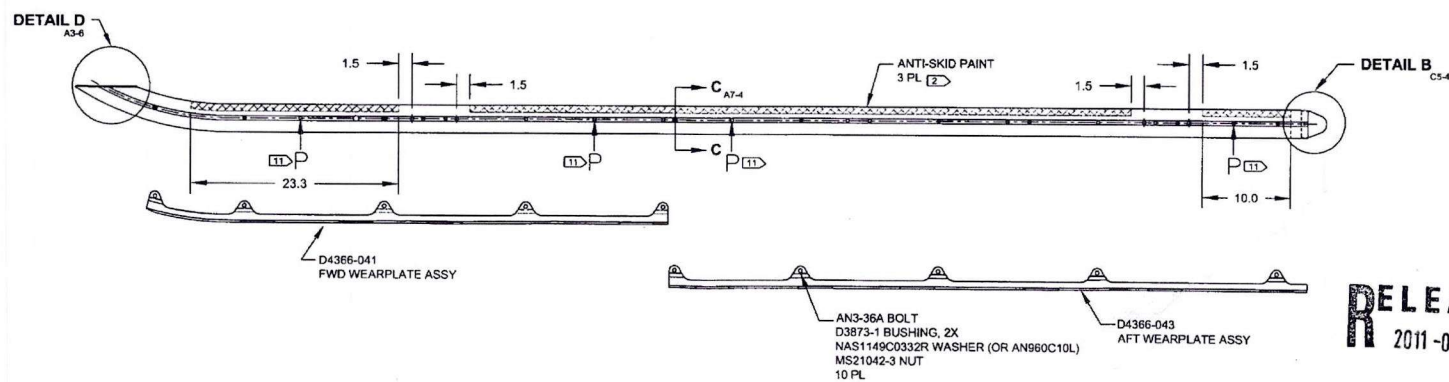
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Other/Details:					



D4361-043 BENDING/DRILL DETAIL



D4361-043 ASSEMBLY/FINISHING DETAIL

DESIGN	SC	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	8	D4361	SHEET 3 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	140	206L/407 SKIDTUBE ASSEMBLIES	NTS
DATE	11.05.05	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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2011-09-12
JN

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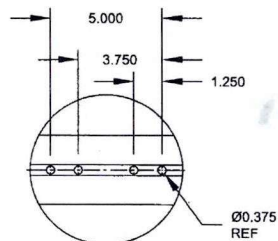


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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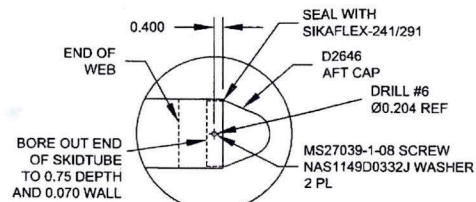
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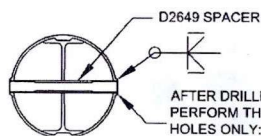
DETAIL A

C3-2
D7-2
C3-3
D6-3



DETAIL B

B2-2
B1-3

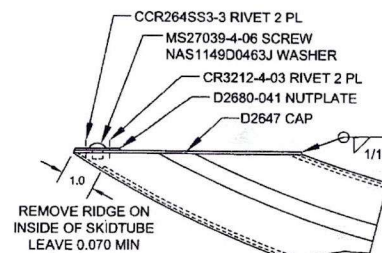


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313 X 0.75 DP

**SECTION C-C
FOR Ø0.375 HOLES
ONLY**

B4-2
B5-3

ORIENTATION OF
D2680-041



DETAIL D

B7-2
B7-3

DETAIL D NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
R 2011-09-12

DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JE</i>	D4361	SHEET 4 OF 4
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	206L/407 SKIDTUBE ASSEMBLIES	NTS
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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					